

5/06

DART AEROSPACE LTD	Work Order:	22180
Description: Hinge Bracket	Part Number:	D2857-1
Drawing: D2857 Rev. A1	Qty:	24 23

RT 03.09.05


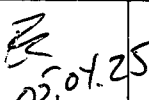

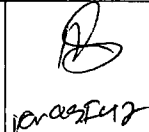
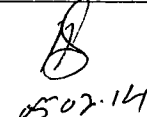
Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	HA	05.01.14	24
2	METAL	Cut blanks 5.2" Material: 2.00" X 1.25" 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8) Batch M16615	SD	03.02.09	24
3	HAAS °	Machine per folio D2857-1	BE	05.02.14	23
4	QC	Inspect Level 2	BE	05.02.15	23
5	METAL	Tumble Deburr any rough edges after tumbling	BE	05.03.15	23
6	METAL °	Acid etch and alodine as per QSI 005 4.3	MM	05.03.21	23
7	QC	Inspect Level 7	Z	05.03.21	23
8	FINISHING	Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3	SG	05/03/22	23
9	QC	Inspect Level 3	MM	05.03.23	23
10	STORES	Identify and stock	CD	05/03/24	23
11	EXPEDITING	Close W/O Cost / Part: 21.41 SAC 05/03/28 (23) 17.51	HA	05.04.26	23

Rev	Date	Change	Revised By	Approved
A	99.01.04	New	KS	
B	99.03.25	Added tumble and acid etch	DM	
C	00.06.22	Removed P/O for powder coat	EC	

RELEASED

BE JUN 26 2009

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.02.14	3	- 1 part scrap, first part (origin off)	 prosser	destroy	 05.01.25		 prosser	 05.02.14

Part No: D2857-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	22180
Description: Hinge Bracket		Part Number:	D2857-1
Inspection Dwg: D2857 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

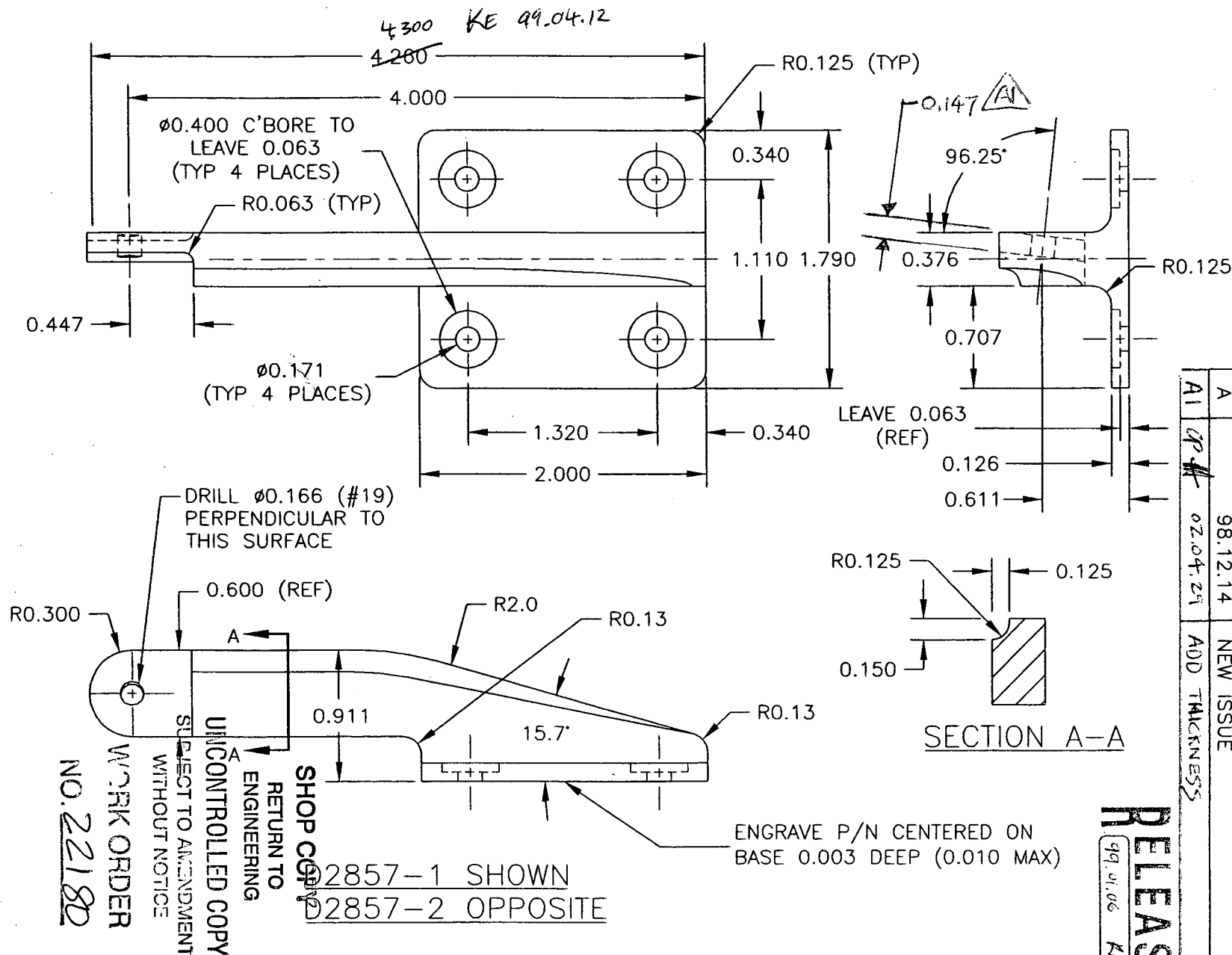
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.308	✓			
0.340	+/-0.010	0.342	✓			
1.110	+/-0.005	1.111	✓			
1.790	+/-0.010	1.788	✓			
1.320	+/-0.005	1.322	✓			
2.000	+/-0.010	2.001	✓			
Ø0.171	+0.005/-0.000	Ø0.172	✓			
0.147	+/-0.010	0.138				
0.376	+/-0.010	0.373	✓			
0.126	+/-0.010	0.129	✓			
0.063	+/-0.010	0.062	✓			
Ø.166	+0.005/-0.000	Ø.166	✓			
0.911	+/-0.010	0.908	✓			
0.600	+/-0.010	0.605	✓			
0.125	+/-0.010	0.119	✓			
0.150	+/-0.010	0.144	✓			

Measured by:	<i>EC</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	05.02.10	Date:	05.04.26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	<i>[Signature]</i>

RELEASED

[Signature] 04.02.17

DARTCOPY
ISSUED

DESIGN	KE	DRAWN BY	JP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	JP	
DATE	98.12.14			
TITLE	HINGE BRACKET			
DRAWING NO.	D2857			
REV. A				
SHEET 1 OF 1				
SCALE	1:1			
ADD THICKNESS				
DATE	98.12.14			
NEW ISSUE				

99.01.06 KE
RELEASED

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 12, 2005
01:18 pm

Work Order No : 0022180
Project Name : D2857-1
Project For : WK506
Work Order Type : Main
Main WO Number :
House Part Number : D2857-1
Description : Hinge Bracket
Manufactured : Yes
Amount Req'd : 24
Amount Done : 0
Start Date : 01-12-05
Est Finish Date : 02-05-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00